

# Work Order ID 71574

Wednesday, July 06, 2011 1:20:28 PM



Page 1

Item ID: D3537-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 7/6/2011 Start Qty: 50.00

Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 50.00

Customer:

Reference:

Approvals: Process Plan: CL Date: 11/6/2011 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3537	Rev C								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3537 <input type="checkbox"/> Dwg Rev: <u>C</u> <input type="checkbox"/> Prog Rev: <u>C</u> <input type="checkbox"/> 2-Deburr								
304, 063	if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

B11-7-11

B11-7-11

counts

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 71574

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Item ID: D3537-1

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Setup Start



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Item Name: Wearpad

Start Date: 7/6/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. □2-Identify as D3537-1

SB1167/11

59

140

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Qty Description Batch □ A/R 2059B Hardcoat  
m18196 □1-Weld as per Dwg D3537 using Jig DT 8210 □2-Remove any weld that penetrated through Wearpad if necessary

59

11-07-27 JBL/EL

150

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

11.01.28

59

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Item ID: D3537-1

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 7/6/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



59

11/07/28



QC

Memo

0.00

Quality Control

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:00

3200F

9:30

Sax & M/L 11/08/02

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

59 & M/L 11/08/02

M117338

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 71574

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Item ID: D3537-1

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Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 7/6/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 50.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Identify as per dwg & Stock Location:

FR47

0.00



Packaging

Memo

0.00

Packaging

54x8 M-11/08/02

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/02

11-08-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



# Picklist Print

Wednesday, July 06, 2011 1:20:26 PM

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Work Order ID: 71574

Parent Item: D3537-1

Parent Item Name: Wearpad





Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA  304/316 Sheet .063		Purchased	No			100	sf	15.1000	0.106	5.578947	6.4		
											11-7-11		

Location

Loc Qty

Loc Code

MAT020

15.1

117275

1.7

117653

13.4

117653

EC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

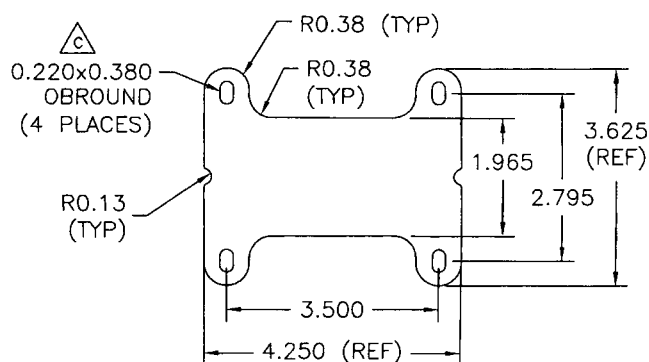
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

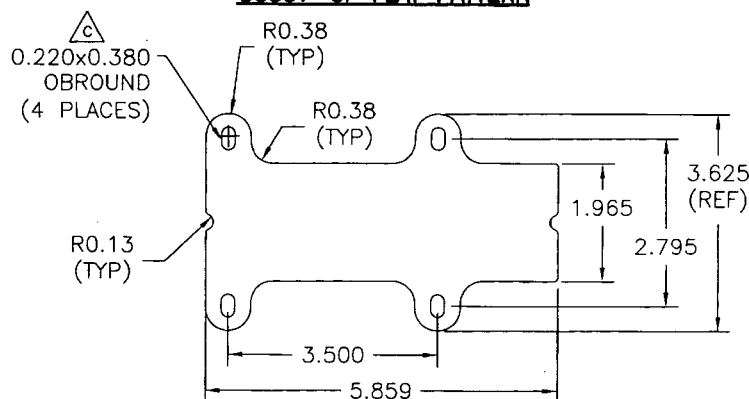
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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### D3537-1F FLAT PATTERN

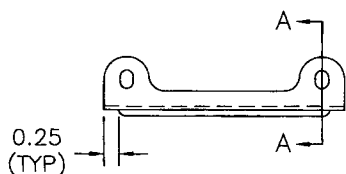


### D3537-3F FLAT PATTERN



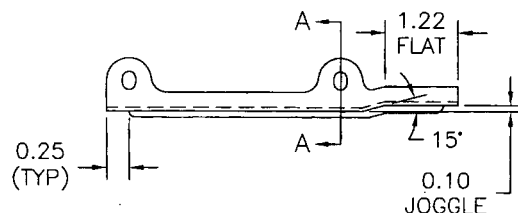
### D3537-1 LONGITUDINAL BEND

(MADE FROM D3537-1F)



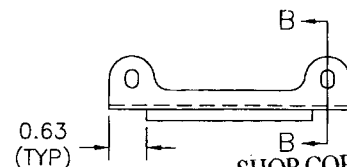
### D3537-3 LONGITUDINAL BEND

(MADE FROM D3537-3F)



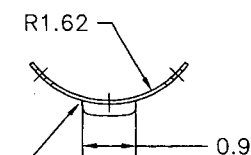
### D3537-5 LONGITUDINAL BEND

(MADE FROM D3537-1F)



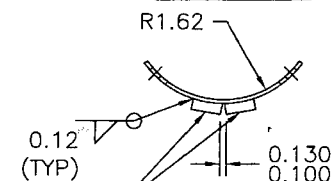
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71374  
C21107/06

### SECTION A-A



APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK

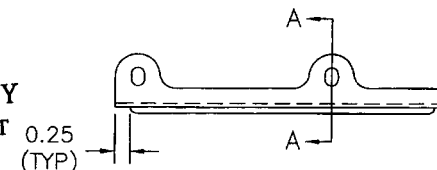
### SECTION B-B



D2941-300  
REMOVE POWDER  
COAT FROM THESE  
SURFACES

### D3537-7 LONGITUDINAL BEND

(MADE FROM D3537-3F)



### D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	#	APPROVED	#	PORT HADLOCK, MA
DATE	07.04.13	DRAWING NO.	D3537	REV. C
		TITLE	WEARPAD	SHEET 1 OF 1
				SCALE
				1:2

RELEASED  
07.05.08 PH  
PER ECN  
962



